

**Fast Dry Epoxy Primer**

**EFP-428/EFP-928**

**CPC 99**

Component A

EFP-428 Fast Dry Epoxy Primer – Gray  
EFP-928 Fast Dry Epoxy Primer – Buff

Component B

EFP-281 Fast Dry Epoxy Primer Catalyst

| RECOMMENDED USE   |   | SURFACE PREPARATION   |   |                                      |
|---|---|---|---|--------------------------------------|
| <p><b>Type:</b> Polyamide-Epoxy Two Component</p> <p><b>Recommended Use:</b><br/>EFP-428 and EFP-928 are fast drying epoxy primers with excellent corrosion resistance for use over a variety of properly prepared substrates. Can be applied as a high build intermediate over zinc primers.</p> |   | <p>The surface to be coated must be free of all contamination, including dust, dirt, oil, grease and oxidation. Chemical treatment or the use of a conversion coating will improve the adhesion and performance properties of the total coating system. Recommended minimal surface preparation for metal substrates is Commercial Blast (SSPC-SP6)</p> |   |                                      |
|   |   | Metal   | Recommended Topcoat                             | Direct To Properly Treated Substrate |
|   |   | <b>Cold Rolled Steel</b>  | AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-400LG | Excellent over blasted surface       |
|   |   | <b>Hot Rolled Steel</b>   | AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-400LG | Excellent over blasted surface       |
|   |   | <b>Galvanized</b>   | AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-400LG | Not Recommended                      |
|   |   | <b>Galvaneal</b>  | AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-400LG | Not Recommended                      |
|   |   | <b>Aluminum</b>   | AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-400LG | Excellent                            |
| PHYSICAL CONSTANTS  |   |   |   |                                      |
| <b>Mixed Voc</b><br>(Varies by color)   | 2.80 lbs/gal  |   |   |                                      |
| <b>Percent Solids By Weight</b><br>(Varies by Color)  | 77.25% - 77.75%   |   |   |                                      |
| <b>Percent Solids By Volume</b><br>(Varies By Color)  | 60.75% - 61.25%   |   |   |                                      |
| <b>Weight Per U.S. Gallon</b><br>(Varies By Color)  | 12.6 lbs/gal ± 2%   |   |   |                                      |
| <b>Flash Points</b><br>(Pensky-Martens)   | EFP-428 55°F (13°C)<br>EFP-928 59°F(15°C)<br>EFP-281 62°F(17°C) |   |   |                                      |
| PERFORMANCE FEATURES  |   |   |   |                                      |
| <b>96 hour humidity resistance</b><br>Excellent   |   |   |   |                                      |
| <b>Adhesion</b><br>Very Good  |   |   |   |                                      |
| <b>In Service Temperature Limitations</b><br>250°F (121°C)  |   |   |   |                                      |
| <b>Permissible Temperatures During Application</b><br>Can be applied at temperatures as low as 40°F (4°C)   |   |   |   |                                      |

| APPLICATION DATA   |                       | SAFETY  |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
|--|-----------------------|---|-----------|------------|------------|---------|------------|---------|------------------------------------|--|---------------------|---------------------|------------------------------------|--|--|----------------------|
| <p><b>Mixing Directions</b><br/>Stir thoroughly before and occasionally during use. Allow a 30-minute digestion period prior to application.<br/>1 part component A (EFP-428 or EFP-928) to 1 part component B (EFP-281).</p>  |                       | <p>These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public. Safe application of paints and coatings requires knowledge of equipment materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness. Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers. Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.</p> <p><b>Precautionary Information</b><br/>Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal. KEEP OUT OF THE REACH OF CHILDREN</p> <p><b>Medical Response</b><br/>Emergency Medical or Spill Control Information (412) 434-4515; CANADA (514) 645 - 1320 Have label information available.</p> <p><b>Material Safety Data Sheet</b><br/>Material Safety Data Sheets for the PPG products mentioned in this publication are available through your PPG Distributor. FOR ADDITIONAL INFORMATION REGARDING THIS PRODUCT, SEE THE MSDS AND LABEL INFORMATION.</p> <p><b>To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries, Inc. is constantly improving its coatings and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG Distributor for the most up-to-date information.</b></p> |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| <p><b>Thinning</b><br/>Must not be thinned where 2.8 lb./gal. VOC compliance is required. May be thinned with Xylene where regulations allow.</p>  |                       |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| <p><b>Pot Life</b><br/>8 Hours</p>   |                       |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| <p><b>Application Equipment</b><br/>Conventional Spray: JGA or PMBC 510 with E tip/needle.777 air cap. A 64-air cap may help control overspray.<br/>Airless Spray: Pressure 1500 psi, tip 0.017" – 0.021"<br/>Brush and Roll: Not recommended</p>  |                       |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| <p><b>Drying Time</b><br/>77°F (25°C) and 50% relative humidity.</p> <table border="1"> <tr> <td>To Touch:</td> <td>30 minutes</td> </tr> <tr> <td>To Handle:</td> <td>2 hours</td> </tr> <tr> <td>To Recoat:</td> <td>2 hours</td> </tr> </table> <p>Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.</p> <table border="1"> <tr> <td colspan="2"><b>Recommended Wet Film Build:</b></td> </tr> <tr> <td>(Spray Application)</td> <td>6.5 mils to 10 mils</td> </tr> <tr> <td colspan="2"><b>Recommended Dry Film Build:</b></td> </tr> <tr> <td></td> <td>4.0 mils to 6.0 mils</td> </tr> </table> <p>Film in excess or below these recommended film builds may cause problems such as, adhesion failure, pigment floatation, solvent popping, slow cure, and accelerated gloss and color failure.</p> |                       |   | To Touch: | 30 minutes | To Handle: | 2 hours | To Recoat: | 2 hours | <b>Recommended Wet Film Build:</b> |  | (Spray Application) | 6.5 mils to 10 mils | <b>Recommended Dry Film Build:</b> |  |  | 4.0 mils to 6.0 mils |
| To Touch:  | 30 minutes            |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| To Handle:   | 2 hours               |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| To Recoat:   | 2 hours               |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| <b>Recommended Wet Film Build:</b>   |                       |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| (Spray Application)  | 6.5 mils to 10 mils   |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| <b>Recommended Dry Film Build:</b>   |                       |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
|  | 4.0 mils to 6.0 mils  |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| <p><b>Recommended Spreading Rate</b><br/>978 sq. ft. at 1.0 mil dry film per U.S. gallon. Coverage figures do not include losses due to mixing, transfer or application of coating or losses due to surface irregularities or porosity.</p>  |                       |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| <p><b>Clean Up</b><br/>MEK, Acetone, or Lacquer Thinner</p>  |                       |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| RTS Combinations:  | EFP-428/928 : EFP-281 |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| Volume Ratio:  | 1 : 1                 |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| Applicable Use Category  | Primer Sealer         |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| VOC Actual (g/L)   | 335                   |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| VOC Actual (lbs/gal)   | 2.8                   |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| VOC Regulatory (less water less exempt) (g/L)  | 335                   |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| VOC Regulatory (less water less exempt) (lbs/gal)  | 2.8                   |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| Density (g/L)  | 1502 - 1505           |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| Density (lbs/gal)  | 12.53 - 12.56         |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| Volatiles wt. %  | 22.3                  |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| Water wt. %  | 0.0                   |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| Exempt wt. %   | 0.0                   |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| Water vol. %   | 0.0                   |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| Exempt vol. %  | 0.0                   |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| APPLICATION PRECAUTIONS AND LIMITATIONS  |                       |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| <p>Apply only when air, product or surface temperature is above 40°F (4°C) and when surface temperature is at least 5°F (3°C) above the dew point. Avoid exterior painting late in the day when dew or condensation are likely to form or when rain is threatening. Not recommended for residential use. Hot rolled steel must be prepared by abrasive blast cleaning</p> <p>Brush and roller application is not recommended.</p>  |                       |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |
| <p><b>PPG Industries</b><br/>Commercial Coatings<br/><i>We're Everywhere You Look</i><br/>PPG Industries<br/>19699 Progress Drive<br/>Strongsville, OH 44149<br/>1-800-647-6050</p> <p>PPG Canada Inc.<br/>2301 Royal Windsor Drive<br/>Mississauga, Ontario L5J 1K5<br/>1-888-310-4762</p>   |                       |   |           |            |            |         |            |         |                                    |  |                     |                     |                                    |  |  |                      |